

Work Order ID 69406

Tuesday, May 10, 2011 3:25:04 PM



Page 1

Item ID: D206-559-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 5/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: P

Date: 11-05-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9527	rev A
IIN-D206-559	rev K

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPPD206-559-011 CHG007

11/11/01 (4)
for MLS 11-10-31
(4)

160

0.00



Packaging

Pick Kit

Memo

0.00

Packaging

11-11-1 (4)

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69406

Tuesday, May 10, 2011 3:25:04 PM



Page 2

Item ID: D206-559-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 5/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				<u>11</u>	<u>11</u>	<u>11</u>	<u>01</u> (4)
180 Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD206-559-011 Location: <u>11</u>	0.00 0.00						<u>11/11/11</u>	(4)
190 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>11/11/11</u>	<u>11-11-01</u>

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, May 10, 2011 3:25:11 PM

Work Order ID: 69406

Parent Item: D206-559-011

Parent Item Name: Bearpaw



Start Date: 5/10/2011

Start Qty: 4.00

Required Date: 5/16/2011

Required Qty: 4.00

Comments:

IPP Rev:C 04.02.17 Blank size changed KJ/JLM
 IPP Rev:D 07-01-02 Was K10007 JLM
 IPP Rev:E 08-05-05 up a chg DD verified by:EC
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified
 By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A Bolt		Purchased	No			160	Each	614.0000	8	32			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST358		300							
				116419		0							
				116704		0							
				117514		200							
				117619		100							
				ST359		314							
				116419		14							
				116704		300							
AN4-20A Bolt		Purchased	No			160	Each	604.0000	8	32			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST359		604							
				115936		104							
				116419		200							
				117514		300							
AN960JD416 Washer	NAS1149D0463J	Purchased	No			160	Each	0.0000	16	64			

m119042. sp 11-11-1

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Tuesday, May 10, 2011 3:25:11 PM

Work Order ID: 69406

Parent Item: D206-559-011

Parent Item Name: Bearpaw

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

D2182B

Manufactured No

160

f

290.0348

1.666

6.664



Rubber Cushion



B73932 SP

Location

Loc Qty

Loc Code

ST410

290.03477

66063

290.03477

(D2182B050) Cut (4) at 5.00" as per dwg ***per kit***

D2274

Manufactured No

160

Each

208.0000

8

32



Radius Block



B72121 SP

Location

Loc Qty

Loc Code

ST010

208

67578

204

68937

4

D2435

Manufactured No

160

Each

1.0000

2

8



Bearpaw, 206



73046 C 11/10/31

Location

Loc Qty

Loc Code

ST497

1

59160

1

D2438

Manufactured No

160

Each

132.0000

4

16



Clamp



B73460 SP 11-11-1

Location

Loc Qty

Loc Code

ST456

132

67830

51

68673

81

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 10, 2011 3:25:12 PM

Work Order ID: 69406

Parent Item: D206-559-011

Parent Item Name: Bearpaw

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

W/W x4 D2529 Washer Manufactured No 160 Each 399.0000 8 32 B 73486 sp-

W/W x4 MS21042L4 Nut Purchased No 160 Each 5,014.000 8 32 m 118451 sp-

W/W x4 QS200-M44S Clamp Purchased No 160 Each 47.0000 2 8 sp 11-11-1

Location Loc Qty Loc Code

ST016 399
66953 399

Location Loc Qty Loc Code

ST300 5014
116823 1214
117441 3000
117601 800

Location Loc Qty Loc Code

ST450 47
115410 1
115589 14
116857 12
117460 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION I
8	12	8	12			16	D2274	RADIUS BLOCK I
2							D2435	19" X 16" BEARPAW I
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP J
8	12	8	12				D2529	WASHER I
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT J
8	12	8	12	8	12		AN4-20A	BOLT J
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP I